

Work Order ID 67791

Wednesday, March 30, 2011 11:35:18 AM



Page 1

Item ID: D2933-1

Accept



Setup Start



Revision ID:

Item Name: Saddle LH In, 206

Stop



Start Date: 3/30/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *H* Date: *4-03-30* Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2933	Rev C

100 0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

SL 11/04/06

40

10

110 0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

SL 11/04/06

4

10

120 0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

SL 11/04/06

4

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID:	D2933-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle LH In, 206					
Start Date:	3/30/2011	Start Qty:	4.00		Cust Item ID:	
Required Date:	4/4/2011	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>aml 11/04/06</i>		<i>4</i>	<i>0</i>		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<i>H</i>	<i>BL</i>	<i>11-4-6</i>	
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M116 964.</i> Memo START TIME: <i>8:40</i> <i>3:20</i> FINISH TIME: <i>9:10</i>	0.00 0.00				<i>H</i>	<i>BL</i>	<i>11-4-12</i>	

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Page 3

Item ID: D2933-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH In, 206

Start Date: 3/30/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 d M 11/04/12

170

Identify as per dwg & Stock Location: St 428

0.00



Packaging

Memo

0.00

Packaging

E 8/11/04/14 (4)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/15

MF

11-04-14

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, March 30, 2011 11:35:24 AM

Page 1

Work Order ID: 67791

Parent Item: D2933-1

Parent Item Name: Saddle LH In, 206



Start Date: 3/30/2011

Required Date: 4/4/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-001

Manufactured

No

100

Each

48.0000

1

4



Saddle Billet



SL 11/04/06

Location

Loc Qty

Loc Code

MAT040

48

64777

28

66965

20

4

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	<i>6777</i>
Description: 206 Saddle, Inboard, Left side		Part Number:	D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.121	.120	.120	.121	
B	0.100	0.140		.121	.120	.120	.121	
C	0.100	0.140		.119	.117	.117	.117	
D	0.210	0.230		.221	.221	.221	.221	
E	1.245	1.255		1.250	1.250	1.250	1.250	
F	1.245	1.255		1.250	1.250	1.250	1.250	
G	2.495	2.505		2.500	2.500	2.500	2.500	
H	0.510	0.515		.513	.519	.513	.513	
I	1.572	1.582		1.577	1.577	1.577	1.577	
J	2.495	2.505		2.500	2.500	2.500	2.500	
K	0.257	0.262		.258	.258	.258	.258	
L	0.312	0.317		.313	.313	.313	.313	
M	0.235	0.240		.238	.238	.238	.238	
N	0.100	0.140		.120	.120	.120	.120	
O	0.540	0.560		.550	.550	.549	.550	
P	0.490	0.510		.500	.500	.499	.500	
Q	3.715	3.725		3.720	3.720	3.720	3.720	
R	2.470	2.510		2.490	2.490	2.490	2.490	
S	0.240	0.270		.252	.252	.252	.252	
T	0.100	0.180		.135	.135	.135	.135	
U	1.625	1.635		1.630	1.630	1.630	1.630	
V	1.362	1.372		1.367	1.367	1.367	1.367	
W	0.316	0.321		.316	.316	.316	.316	
X	1.125	1.145		1.136	1.136	1.136	1.136	
Y	1.565	1.585		1.576	1.576	1.576	1.576	
Z	0.178	0.198		.188	.188	.188	.188	
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: <i>SL</i>	Date: 11/04/06
Audited by: <i>cmk</i>	Date: 11/04/06
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	<i>[Signature]</i>

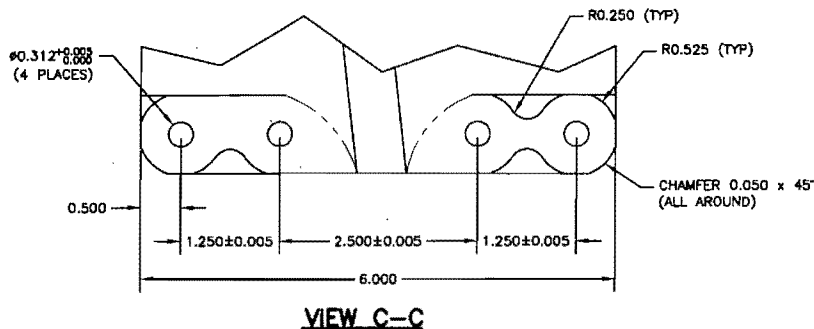
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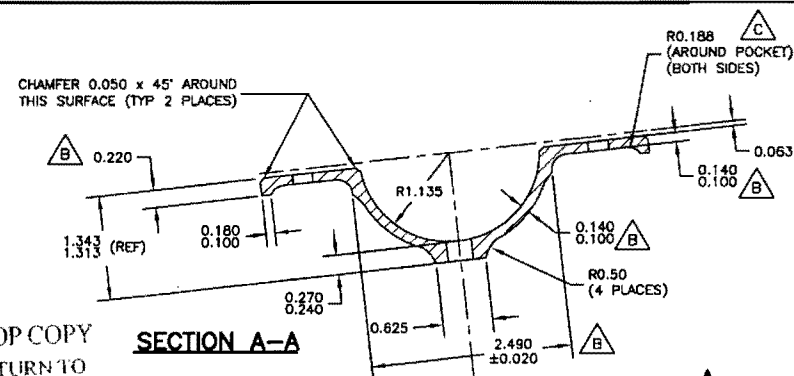
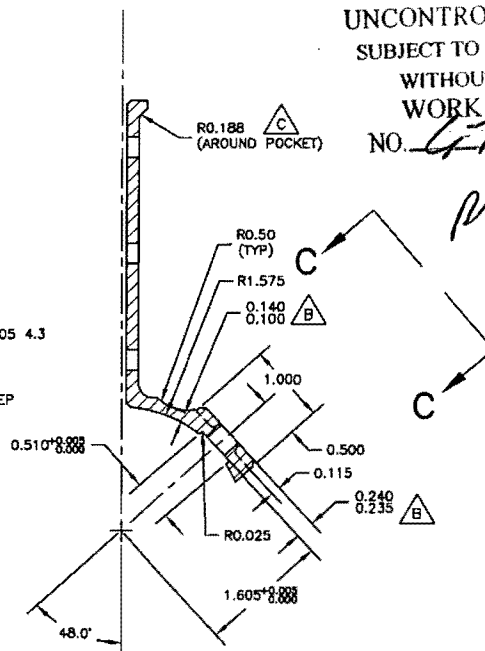
NOTE: Date & initial all entries



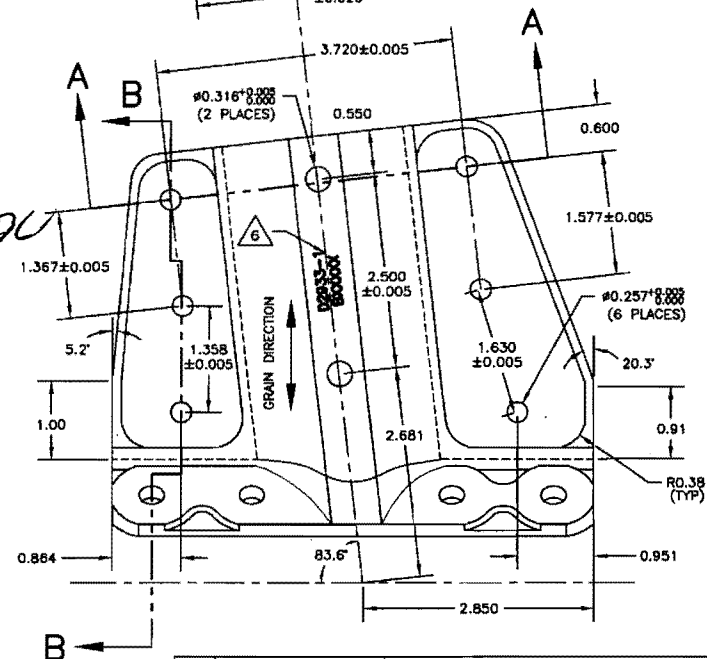
D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. *67791*
PA 11-0370



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	<i>PH</i>	DRAWN BY <i>CB</i>
CHECKED	<i>PH</i>	APPROVED <i>PH</i>
DATE	06.11.09	TITLE SADDLE INSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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DART DART AEROSPACE USA, INC.
 BELLEVILLE, MO

07.02.12 *PH*

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